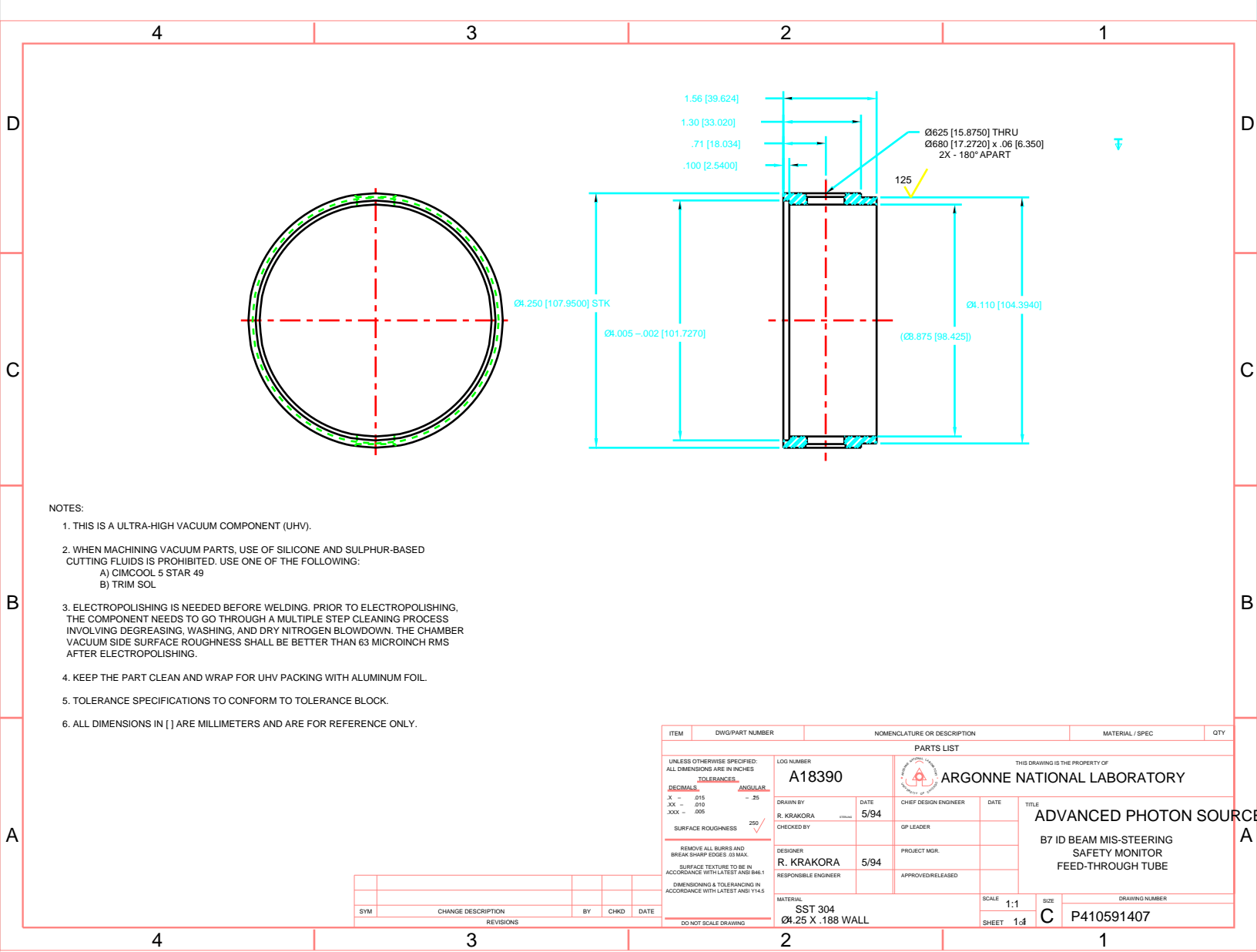


(Ø)	PLOT SCALE: 1=1	DWG. SCALE: 1	
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- NOTES:
1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
  2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
  3. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE COMPONENT NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING, AND DRY NITROGEN BLOWDOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROINCH RMS AFTER ELECTROPOLISHING.
  4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
  5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
  6. ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
LOG NUMBER <b>A18390</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
DRAWN BY R. KRAKORA		DATE 5/94	CHIEF DESIGN ENGINEER	DATE
CHECKED BY			GP LEADER	
DESIGNER R. KRAKORA		5/94	PROJECT MGR.	
RESPONSIBLE ENGINEER			APPROVED/RELEASED	
MATERIAL SST 304 Ø.25 X .188 WALL		SCALE 1:1	SIZE C	DRAWING NUMBER P410591407
SYMBOL		CHANGE DESCRIPTION	BY	CHKD
REVISIONS				
DO NOT SCALE DRAWING				